

Work Order ID 70872

Thursday, June 16, 2011 12:51:59 PM

Page 1

Item ID: D3016-17

Accept

Setup Start

Revision ID:

Stop

Item Name: Gusset

Start Date: 6/16/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3016

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3016 ☒ Dwg Rev: A ☒ Prog Rev: A ☐ 2-

Deburr if necessary

4130 .00

B11-616



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-616

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subtotal

count
x22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item ID: D3016-17

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset

Start Date: 6/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and bag with light oil (Vactra oil #2), then Stock *****STOCK IN LARGE FAB***** Location: <i>W/A 025</i>								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

*EL 11-6-16- (X22)**11/6/2011**MF**11-06-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 16, 2011 12:51:57 PM

Page 1

Work Order ID: 70872

Parent Item: D3016-17

Parent Item Name: Gusset



Start Date: 6/16/2011

Required Date: 6/20/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP B 03.05.09 Reformat KJ/RF

IPP Rev:C 08-04-11 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.049 		Purchased	No			100	sf	11.9000	0.0173	0.182105			
4130 Sheet .049 													

B11-6-16

Location

Loc Qty

Loc Code

MAT020

11.9

11612

9.4

16443

2.5

16443

22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

2107812

DEO ATTACHED

RELEASED
01.05.30 *#*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

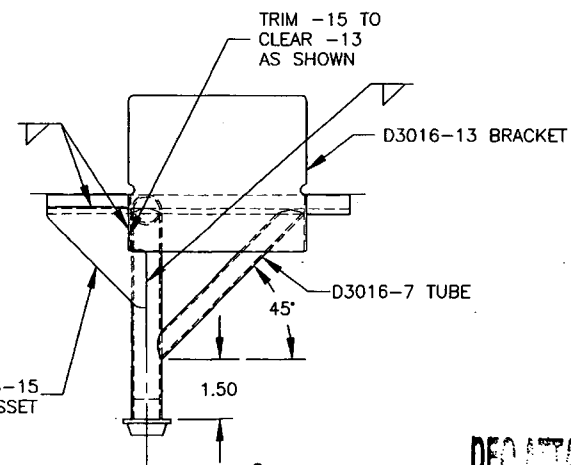
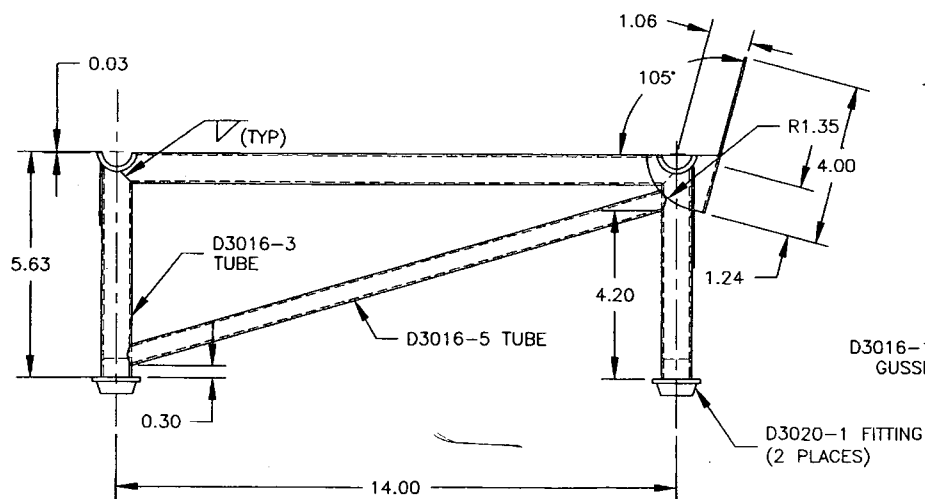
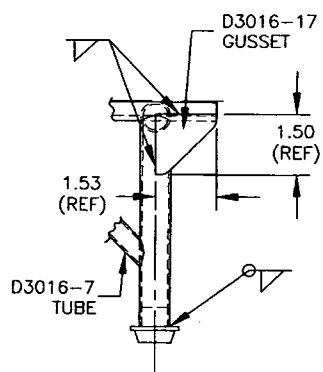
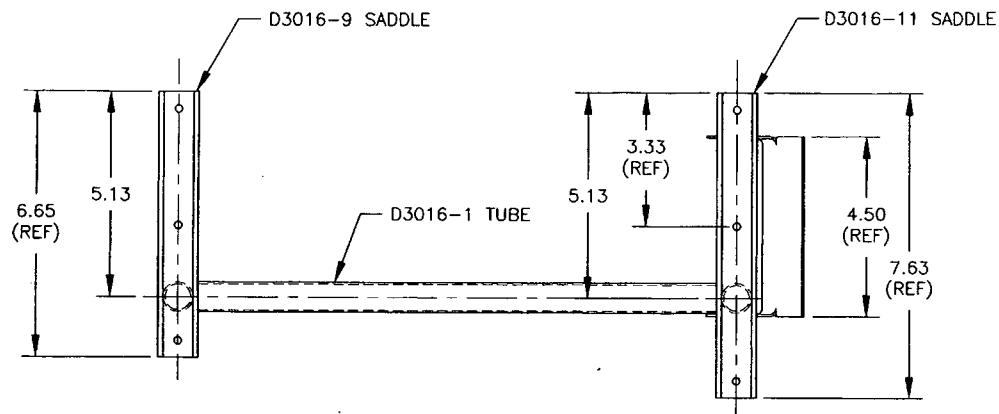
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NOTE: Date & initial all entries

D3016-041 SEAT FRAME ASSEMBLY



DETACHED
RELEASED
01.05.30

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DESIGN	CP	DRAWN BY	CP	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3016	REV. A SHEET 2 OF 3
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	SCALE	1:3

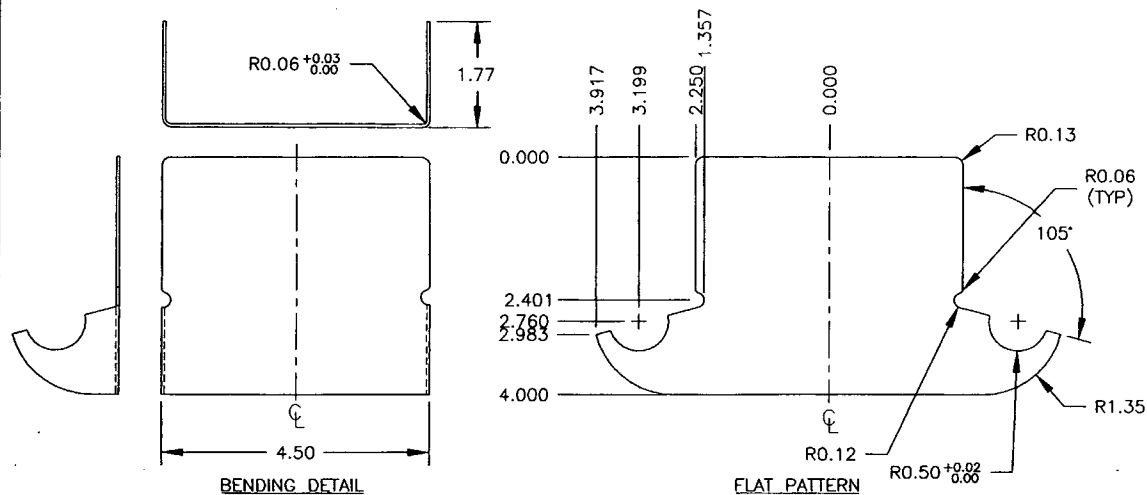
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

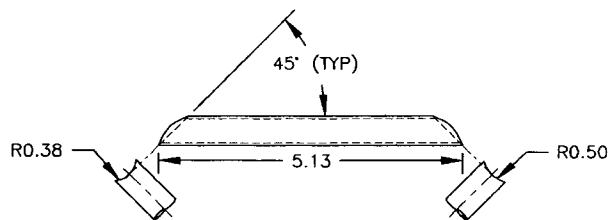
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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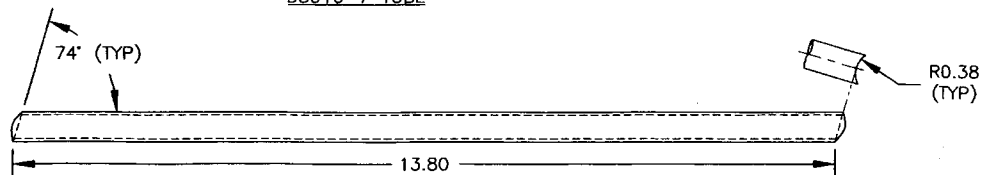
NOTE: Date & initial all entries



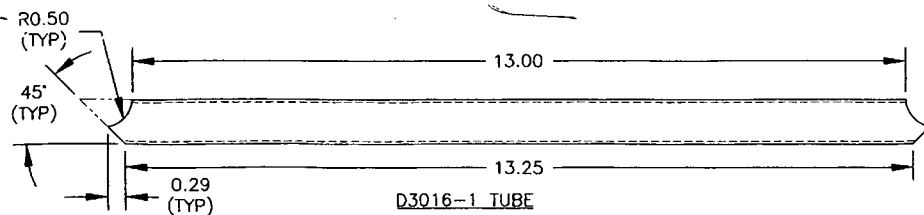
D3016-13 BRACKET



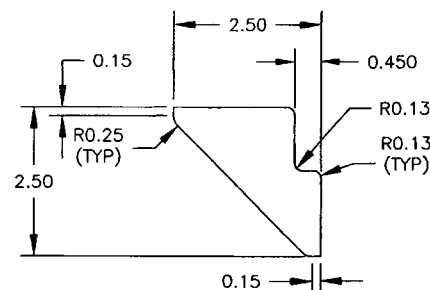
D3016-7 TUBE



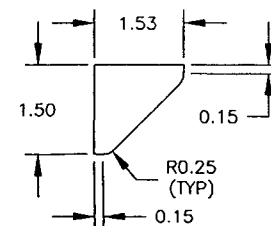
D3016-5 TUBE



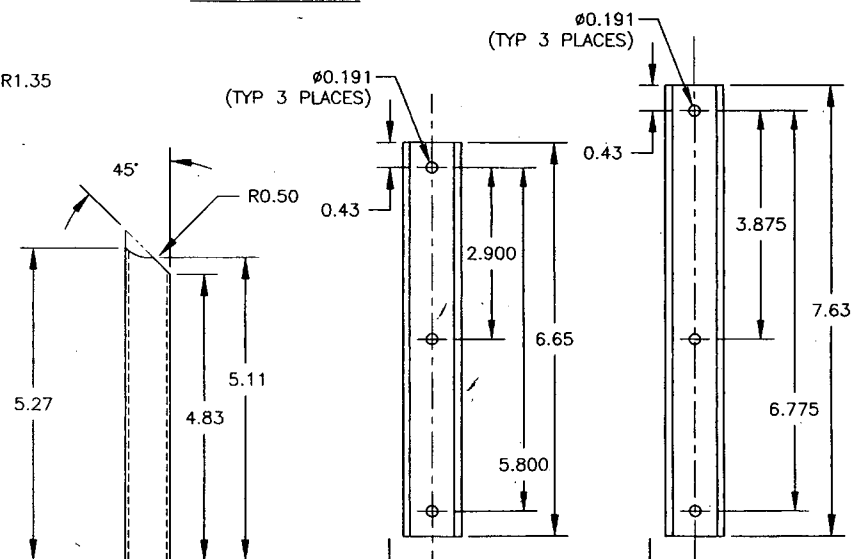
D3016-1 TUBE



D3016-15 GUSSET



D3016-17 GUSSET



D3016-3 TUBE

D3016-9 SADDLE

DEO ATTACHED
RELEASED
9.05.30

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DESIGN	CP	DRAWN BY	CP	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D3016
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	REV. A	SHEET 3 OF 3
				SCALE	1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>WAP</i>	DE APPR. <i>WAP</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	

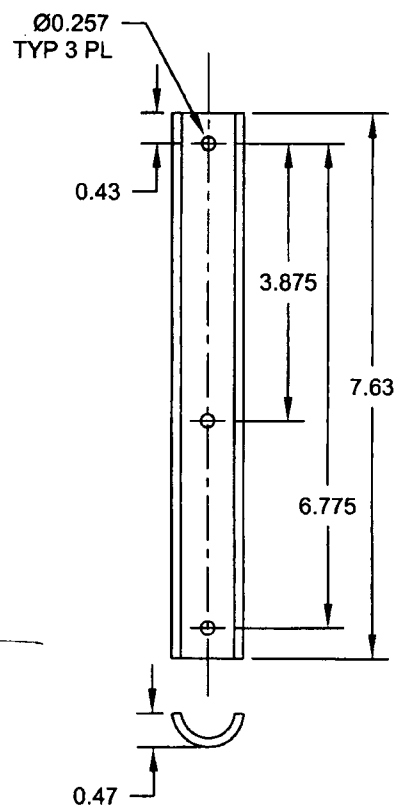
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

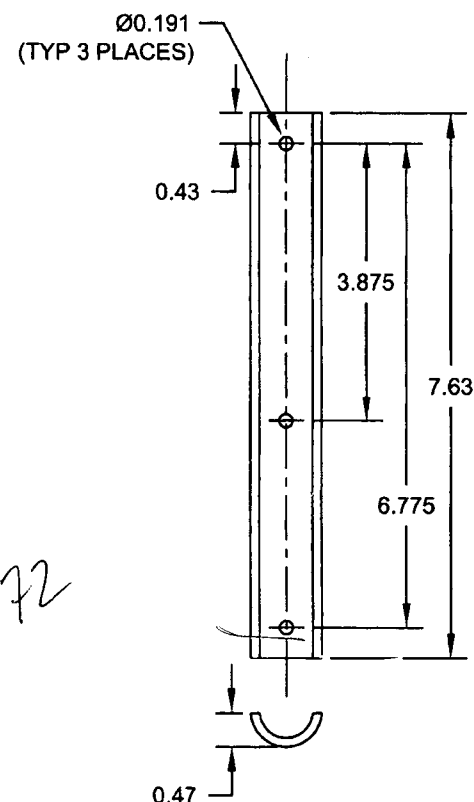
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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